

5/10  
DART AEROSPACE LTD

Work Order: 22323

Description: Blade Fitting LH

Part Number: D2742-1

Dwg: D2742 Rev. B1; DSK-050 Rev. A; D6103 Rev. A

Qty: 7

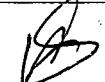
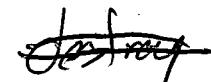
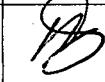
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <b>Dwg not required</b>	PF	05.01.26	8
2	PG	Issue P/O: <u>7007417</u> Material: 7075-T6/T651 (QQ-A-200/11 or QQ-A-225/9) 3.250" OD x 12.500" Long (+0.100/-0.030) per P/N D6103-001 <b>Certificate of Conformity is required</b>		IL	08-01-27/10
3	RG	Receive and Inspect for transit damage <b>Ensure Certificate of Conformity is attached</b>	CD	05/02/02	8
4	QC6	Inspect dimensions as per Dwg D6103	EC	05.04.19	8
5	QC6	Machine as per Folio FA099 ( Note: Lathe work only ) <u>ISSUE P/O 2007413 FOR DSK-050</u>	IL	05.04.20	8
6	QC2	Inspect parts as they come off the CNC machine <u>RECEIVE &amp; INSPECT FOR TRANSIT DAMAGE</u>	CD	05/05/13	8
7	QC8	Second inspection <u>dimensional check</u>	EC	05/06/25	8
8	MV	Machine as per Folio FA099 ( Note: HAAS work! )	EC	05/06/27	7
9	QC2	Inspect parts as they come off the CNC machine	EC	05/06/28	7
10	QC8	Second inspection	ML	05/06/27	7
11	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05/07/04	7
12	FP	Powder Coat White (REF 4.3.5.1) as per QSI 005 4.3	ML	05/07/11	7
13	QC3	Inspect Powder Coat	ML	05/07/11	7
14	FP	Install ALS4-1032-225 Insert as per Dwg D2742 Qty Part Number Description Batch 4 ALS4-1032-225 Insert <u>M14576</u>	EC	05/07/13	7
15	QC5	Inspect part 100% for completeness on the W/O	ML	05/08/02	7
16	FP	Identify and Stock	ML	05/08/02	7
17	AC	Cost / part <u>244.16</u>	SK	05.08.09	7
18	DC	Close W/O <u>203.73</u> Inspect Level 21	PF	05/08/03	7

Rev	Date	Change	Revised By	Approved
A	98.09.09	New Issue	DS/CP	
B	98.11.02	Blank size, inspection level added	KS	
C	99.02.02	Changed Procedure, Insert	DM	
D	00.11.01	Removed P/O for Powder Coat & for turning	EC	
E	00.11.17	Added picking DSK-050	EC	
F	02.05.07	Added turning sequence( remove DSK 050 )	NG	
G	02.09.20	Re-format; Added P/O	KJ	
H	04.03.09	Added Steps 3 & 4	KJ/RF	RF

RELEASED  
04.04.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/06/02	8	Part was not straight on Parallel Axis	 VCG/02	 put in Quarantine	 05/06/02	 05/06/02	 VCG/02	 05/06/02

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: 

Date: 05/08/02

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	22323
Description: Blade Fitting		Part Number:	D2742-1
Inspection Dwg: D2742 Rev: B1; DSK050 Rev: A			Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
LATHE	8.000	+0.030/-0.000	8.003	✓		
	9.250	+/-0.010	9.249	✓		
	Ø3.240	+0.005/-0.000	3.240	—		
	Ø3.125	+0.005/-0.000	3.126	—		
	Ø2.780	+0.005/-0.000	2.780	—		
	Ø2.450	+0.005/-0.000	2.450	—		
	0.125 x 45°	+/-0.010	0.125 x 45°	—		
	0.125	+/-0.010	0.123	—		
	12.50	+0.030/-0.000	12.500	—		
HAAS	0.100 x 0.135	N/A	N/A			
	0.500	+0.005/-0.000	0.500	✓		
	1.500	+/-0.005	1.498	✓		
	11.46	+/-0.030	11.487	✓		
	1.180	+/-0.005	1.182	✓		
	3.150	+/-0.005	3.151	—		
	3.500	+/-0.005	3.498	—		
	Ø0.484	+0.005/-0.000	0.484	—		
	Ø0.508	+0.005/-0.000	0.508	—		
	1.000	+/-0.010	1.001	✓		
	0.926	+/-0.010	0.928	✓		
	0.500	+/-0.010	0.497	✓		
	1.230	+/-0.010	1.231	—		
	0.125	+/-0.010	0.132	—		
	2.620	+/-0.010	2.626	✓		
	0.297	+0.005/-0.000	0.297	✓		
	Ø0.430 x 0.045	+/-0.010	0.433 x 0.041	✓		

Measured by:	CP	Audited by:	ML	Prototype Approval:	N/A
Date:	05/06/26	Date:	05/06/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.12	New Issue	KJ/RF	PF

RELEASED

04.01.15

Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jan 25, 2005  
03:20 pm

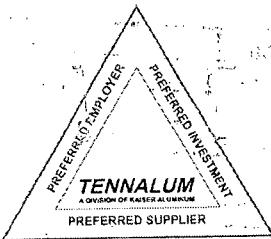
Work Order No : 0022323  
 Project Name : D2742-1  
 Project For : WK510  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D2742-1  
 Description : Blade Fitting, LH  
 Manufactured : Yes  
 Amount Req'd : 8  
 Amount Done : 0  
 Start Date : 01-25-05  
 Est Finish Date : 03-03-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :  
 Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Margin : 0.000%  
 Actual Margin : 0.000%  
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

# KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum  
PO Box 669  
Jackson, TN 38302  
731-423-2811



## CERTIFIED TEST REPORT

<http://KaiserEngProd.com>

CUSTOMER PO NUMBER: CA2192		CUSTOMER PART NUMBER: 024363		PRODUCT DESCRIPTION: SMS CF RD Specific Length			
KAISER ORDER NUMBER: 595936	LINE ITEM: 1	SHIP DATE: 11/15/2004	ALLOY: 7075	TEMPER: T651			
WEIGHT SHIPPED: 969 lbs.	QUANTITY: 8 pcs.	B/L NUMBER: 22409	DIAM/DAF/THKNS: 3.250 in.	WIDTH: 0.000 in.	LENGTH: 144.0 in.		
SHIP TO: Copper & Brass Sales Inc 6555 E Davison Detroit, MI 48212 USA				SOLD TO: Copper & Brass Sales Inc Attn: Accounts Payable P. O. Box 5116 Southfield, MI 48086-5116 USA			

Test Code: 1000

### Actual Physical Properties

Lot Number	LONG.	LONG.	LONG.
	UTS	YTS	ELONG.
	ksi	ksi	%
20061200	80.2	72.9	16.0

### Chemical Composition, WT. % (Aluminum Remainder)

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHERS EACH	OTHERS TOTAL
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05
Min					1.2		2.1	0.18	5.1

### Specifications

Standard: ISO 9001, ASTMB211-03, AMS4122G, AMS-QQ-A-225/9

### Miscellaneous Notes

This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. This material meets the requirements of (cold finished) T6 temper, AMS 4122J and QQ-A-225/9E (CANCELLED).

### CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

*John Rennekamp*

Plant Serial: 44125

Kaiser Order Number: 595936

Line Item: 1